

Work Order ID 52979

October 20, 2009 11:42:57 AM



Page 1

Item ID: D3943-5

Accept



Setup Start



Revision ID: A-B

Item Name: Plate

Stop



Start Date: 10/21/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/23/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-10-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3943

Rev. B.

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3943

Dwg Rev: A B

Prog Rev: A B

2-Deburr if necessary

Jul 01-10-27

B 9-10-23

PJO

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 9-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: MS Date: 09.10.27
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.10.27	100	Rev. of DWG is not the same as the Rev of the W/O & WORKTEST PROGRAM	MS	PART NOT AFFECTED ON THIS W/O by rev change.	N/A.	N/A.	N/A.	MS

NOTE: Date & initial all entries

Work Order ID 52979

October 20, 2009 11:42:57 AM



Page 2

Item ID: D3943-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Plate

Start Date: 10/21/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/23/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>Jul 09.10.23</i>					
130 Mill Conv Conventional Milling Machine	Manufacture as per dwg Memo 1-OPEN TO TAP DRILL SIZE FOR 5/8" THREAD 2-DRILL TAP 1/4"-28 AS PER DWG 3-MILL RAD	0.00 0.00		<i>Jul 09.10.23</i>					
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>2) 5 09/10/23</i>					

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 52979

October 20, 2009 11:42:57 AM



Page 3

Item ID: D3943-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Plate

Start Date: 10/21/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/23/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Identify as per dwg & Stock Location: 139C

0.00

Memo

0.00

Packaging

9/16/23. 90 SP

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09.10.27
09-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 20, 2009 11:42:57 AM

Page 1

Work Order ID: 52979



Parent Item: D3943-5RevA



Parent Item Name: Plate

Start Date: 10/21/2009

Required Date: 10/23/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010B0.375X03.500		Purchased	No			100	f	15.0000	1.0400			
1010-1025 Steel Bar .375 x 3.500												

10 9-10-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

15

102179

3.5

110740

11.5

102179

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

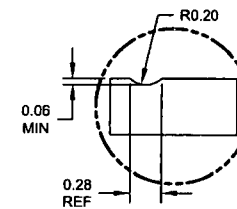
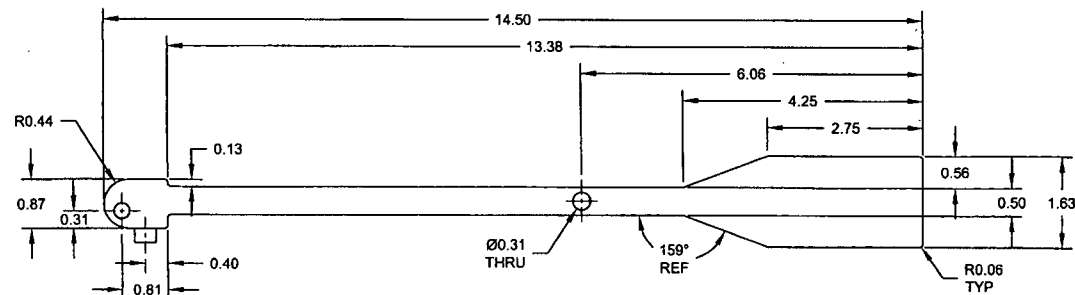
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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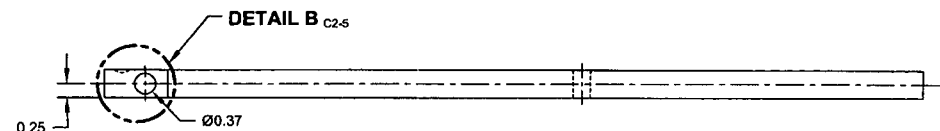
NOTE: Date & initial all entries

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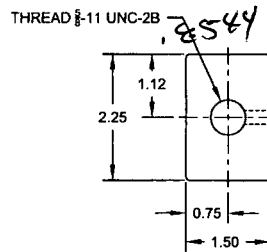


DETAIL B-B
(DIMPLE DETAIL)
(SCALE 2X)

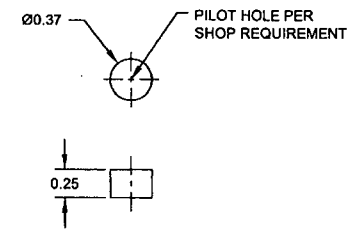
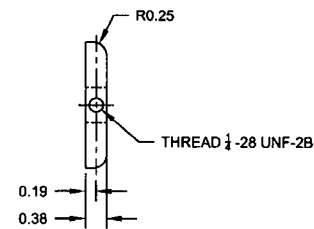
#52979



D3943-3 HANDLE EXTENSION



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

NOTES -11/-13:

- 1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S
- OR: MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B
- 7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

- 2) FINISH -3: SPRAY PAINT YELLOW WITH BERTRAND CG103IB PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A

RELEASED
2009-10-19

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3943	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	09.10.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERRED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
21	1			D2890-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
28			1	D3954-8	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN860-516	WASHER	
33	1			MS21042L6	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
41	1			S-1475	SPRING	REID SUPPLY
42	1			3408A59	BALL PLUNGER	McMASTER CARR
43	3			HX-15	SOCKET HEAD CAP SCREW 1/2-20 UNC X 1.0 LG	HASKINS

REFERENCE ONLY

w/o 52979

RELEASED
2009-10-19

B	SHT 1 PL ITEM 31 WAS AN4-10A, ITEM 32 WAS AN860-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.		AJS	09.10.15
A	NEW ISSUE		AJS	09.05.13
REV.	DESCRIPTION		BY	DATE
DESIGN	DSTOW / AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3943	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	GROSS WEIGHT TOW CRANK ASSY	NTS	
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